

Date: Friday, 1/25/2008 11:00:26 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services : Drawing Name : 407.FWD X-TUBE
 Job Number : 37004
 Estimate Number : 12348
 P.O. Number :
 This Issue : 1/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D407667105
 First Issue : / / Type : LANDING GEAR Drawing Number : D407-667-145 REV B
 Previous Run : 37003 Material :
 Written By : Due Date : 3/10/2008 Qty: 1 Um: Each
 Checked & Approved By : 08 01 25
 Comment : Est Rev. 05.09.01 Add holes for compatibility with Bell
 Skid tubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D407-667-105 CHG002

08.02.28
 08/04/08

2.0 D6010115 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6010-115 Crosstube 8 32308

Check OD = 2.250"; ID = 1.610"

BG 08.02.27

①

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8673on both ends as per Folio FA249

2-Turn first side as per Folio FA249

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-145.

BG 08.03.02

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 08.03.02 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 11:00:26 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 37004

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA249

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-145.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-145

Inside of Cuff(Donot engrave on outside of tube)

050302

①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

050302

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/03/03

①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

ANM 8-3-11

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/11

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JP 8-3-11

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE


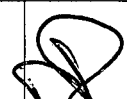



Bend tube as per Dwg D407-667-145 using CNC bender program 407-fw and Folio FT016

DP 8-3-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D407-667-105 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: 37004		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-03-28	12	TUBE IS TOO HIGH + TOO WIDE		REMOVE 0.125" OFF BOTH CURTS AND RE-MEASURE. RE-ENGINE P/N + S/N	 8-3-28	 08/04/02	 08-03-28	 08/04/02

NOTE: Date & initial all entries

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Drawing Name: 407 FWD X-TUBE

Job Number: 37004

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



Handwritten: 08-03-28



Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D407-667-145. Drill all (3) top holes

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg 407-667-145. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-145. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D407-667-145.

8-C'sink holes as per Dwg D407-667-145: Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-145

Handwritten: EY/SD
8-9-31

Handwritten: AWM 8-4-1

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Handwritten: AWM 8-4-1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: S 08/04/02 (SL)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: S 08/04/02 (SL)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 407 FWD X-TUBE

Job Number: 37004

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 6062 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C262/04/030

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

L 8/4/03 GL

19.0

Q00

DIMENSIONAL CHECK

Q05



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

FT 08-04-04

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

M 08 04 03

(1)

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

FT 08-04-04

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

35900

M 08 04 01

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

36064

M 08 04 04

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 37004

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

37341

ml 08 04 04

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

33693

ml 08 04 07

26.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

105057

ml 08 04 04

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

106484

ml 08 04 07

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D407-667-145. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.

see attachment 08.04.07

ml 08 04 07 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 37004

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M106242

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

33.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Batch: M107013

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

4 AN5-30A

Description Batch

Bolt

M105144

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

18 AN960JD516

Description Batch

Washer

M106654

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 37004

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/08 (KL)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-667-105

Location: 53

PPP Rev: 15

8/4/8

scd (1x)

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



cmf

08-04-08

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37004
Description: Crosstube Assembly	Part Number:	D407-667-145
Inspection Dwg: D407-667-145 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.241	✓			
	1.865	+0.005/-0.000	1.869	✓			
	1.878	+0.005/-0.000	1.882	✓			
	1.970	+0.005/-0.000	1.974	✓			
	2.030	+0.005/-0.000	2.034	✓			
	2.165	+0.005/-0.000	2.170	✓			
	0.125	+/-0.010	0.125	✓			
	R0.063	+/-0.010	0.063	✓			
	R0.500	+/-0.010	0.500	✓			
	R0.063	+/-0.010	0.063	✓			
	4.438	+/-0.010	4.438	✓			
SIDE B	2.240	+0.005/-0.000	2.242	✓			
	1.865	+0.005/-0.000	1.869	✓			
	1.878	+0.005/-0.000	1.882	✓			
	1.970	+0.005/-0.000	1.973	✓			
	2.030	+0.005/-0.000	2.033	✓			
	2.165	+0.005/-0.000	2.169	✓			
	0.125	+/-0.010	0.125	✓			
	R0.063	+/-0.010	0.063	✓			
	R0.500	+/-0.010	0.500	✓			
	R0.063	+/-0.010	0.063	✓			
	4.438	+/-0.010	4.438	✓			
	113.20	+/-0.020	113.2	✓			

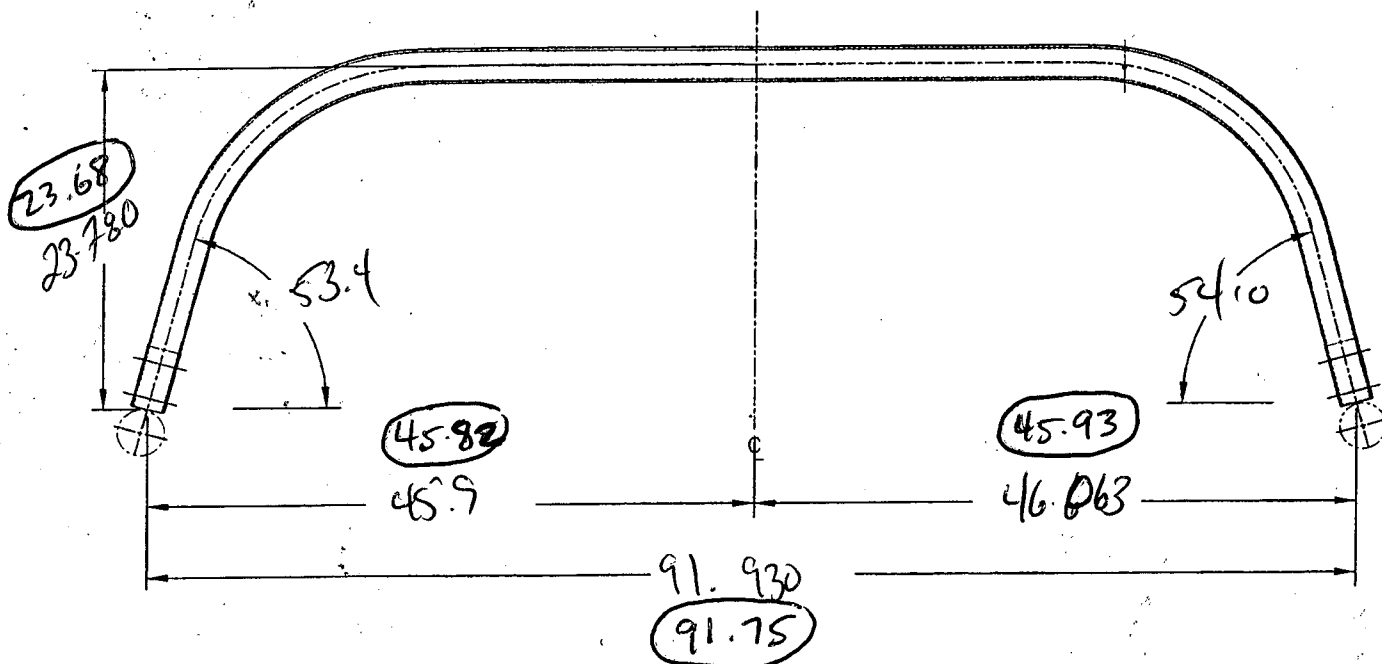
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08/03/02	Date:	08/03/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-105)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

5-10-18
STP 1
FEB 5
P. 11

DART AEROSPACE LTD		Work Order:	37004
Description: Crosstube High Fwd (407)		Part Number:	D407-667-105
Inspection Dwg: D407-667-145 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.48	23.60
1/2 Span	45.88	46.0
Angle	54	56
Total Span	91.76	92.0



Comments
TUBE WAS TOO HIGH SO 0.125" WAS CUT OFF BOTH ENDS.
CIRCLED DIMENSIONS ARE NEW DIMENSIONS.
TUBE NOW FITS WELL IN JIG.

QC15 Inspection	<i>[Signature]</i>
Date	08-03-28

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED DS	DRAWING NO. D407-667-145	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD) NTS	
A	02.05.08	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26

UNDER REVIEW
06.08.10
re-draw detail
PH
07.06.19

Qty	Part Number	Description
X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
1	D6010-115	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-20	CLAMP

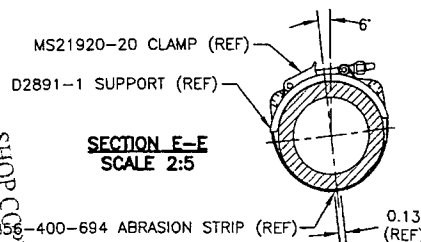
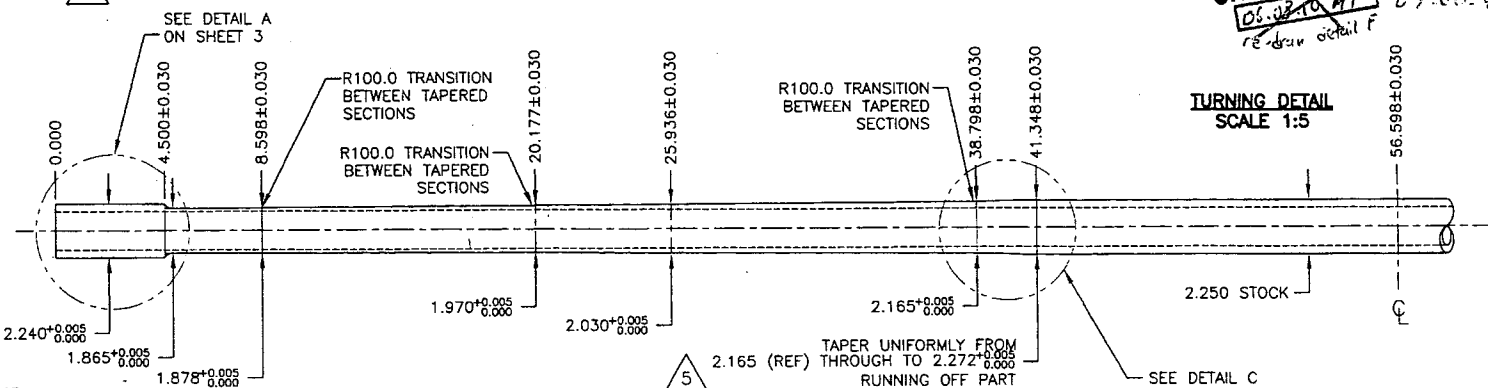
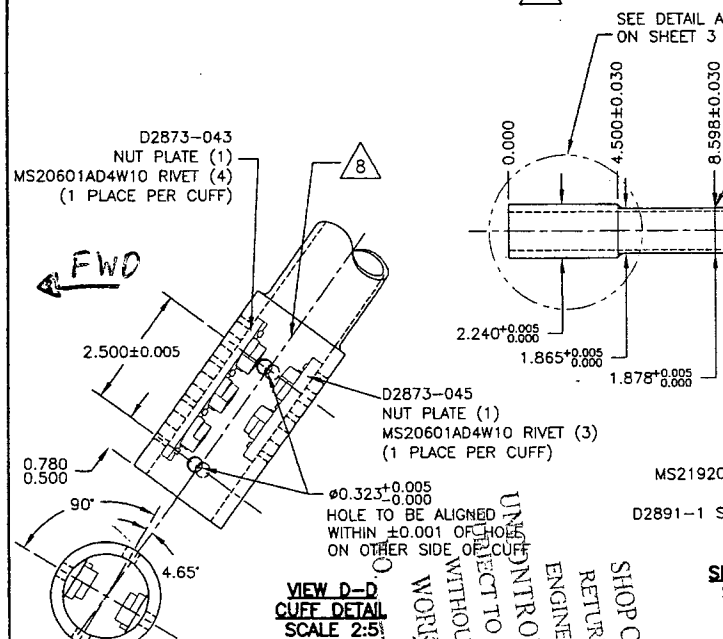
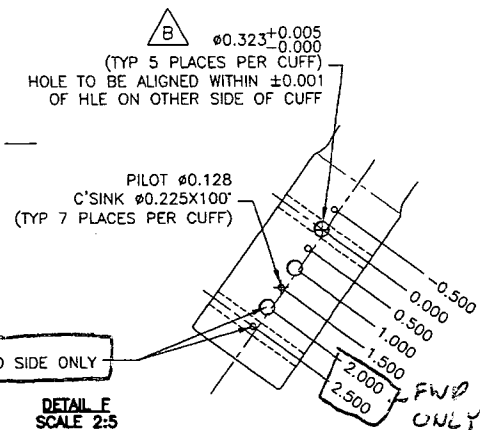
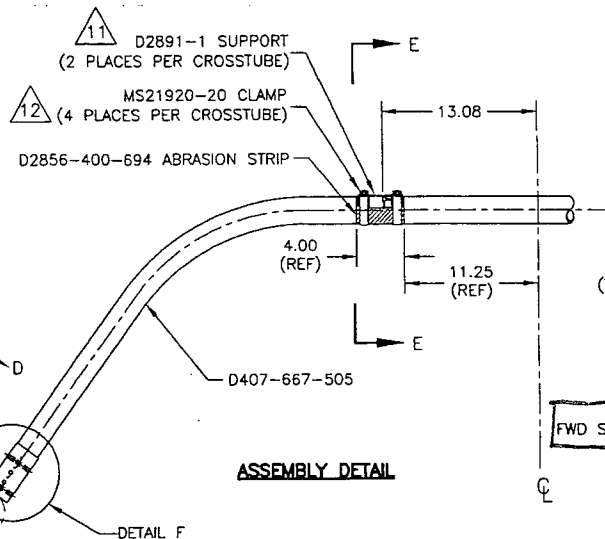
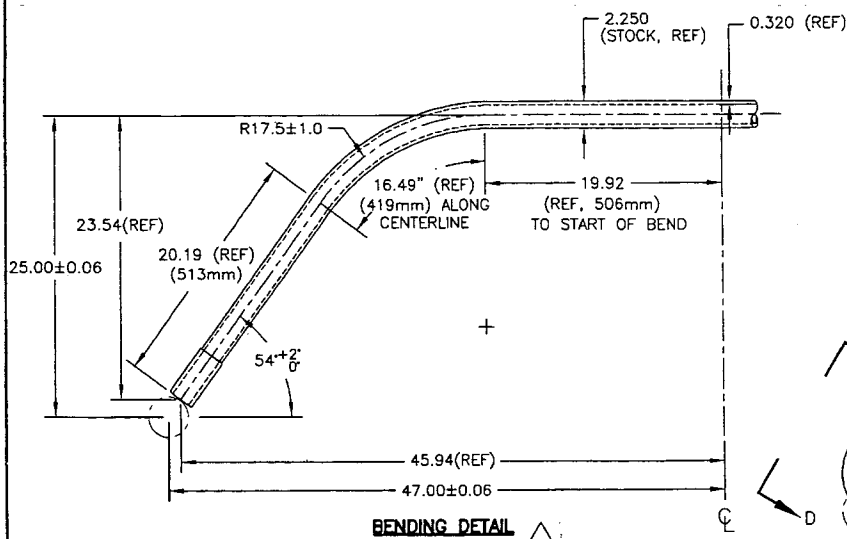
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT (OPTIONAL).
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37004

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED # DS	APPROVED # DS	DRAWING NO. D407-667-145	SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)			SCALE 1:10

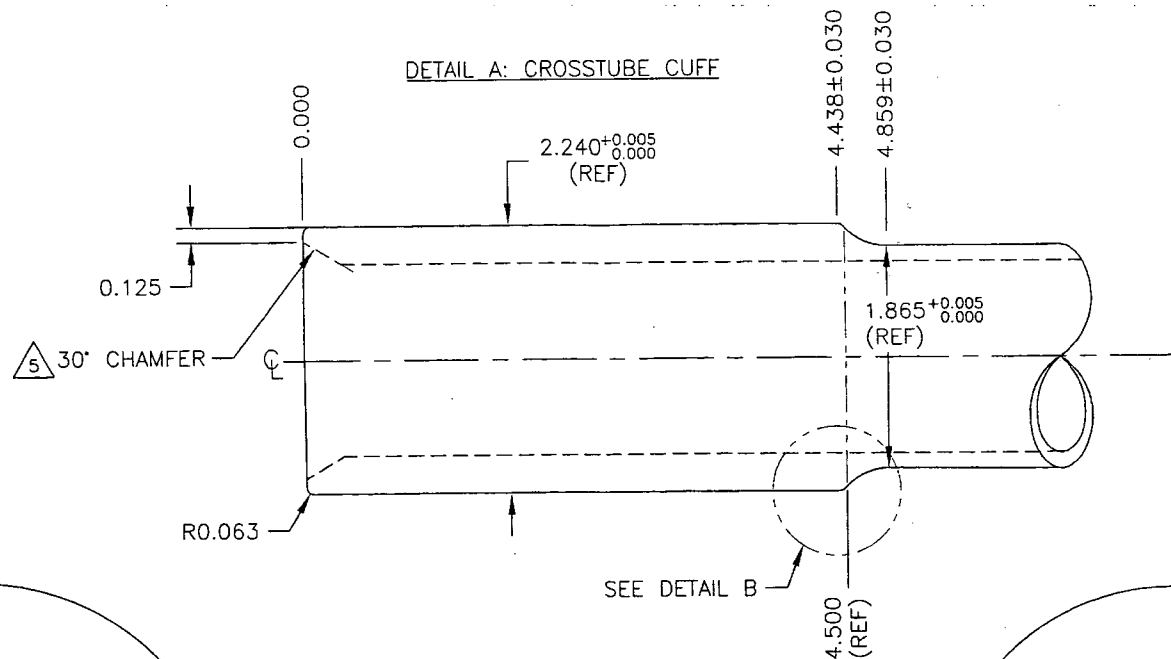
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RETURN TO
ENGINEERING
WITHOUT NOTICE
WORK ORDER
M 7004

UNDER REVIEW
05.07.26
re-draw detail F

RELEASED
05.07.26

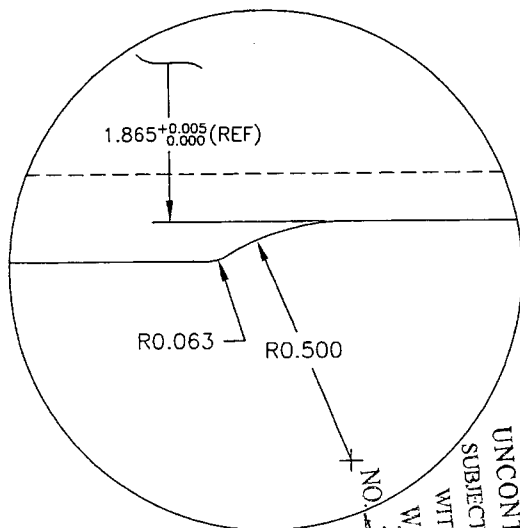
mlh

DETAIL A: CROSSTUBE CUFF



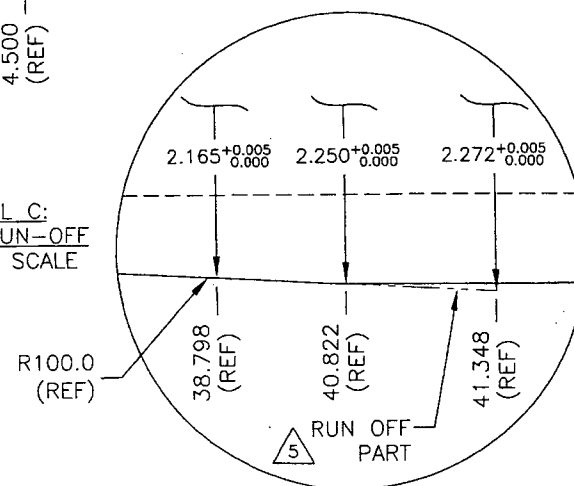
UNDER REVIEW PH
05-08-10 PH
Re-drawn Detail F 02.06.10

05-07-26



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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NO. 37004

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DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. WARRICKS, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
# DS	# DS	# DS	# DS	D407-667-145	SHEET 3 OF 3
DATE	05.07.26	TITLE	CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE	1:1





LIQUID PENETRANT TEST REPORT

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PAGE 1 OF 1

CLIENT	DART AEROSPACE	DATE	APR 3, 2008	TIME	AM <input type="checkbox"/> PM <input type="checkbox"/>
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1263		
ADDRESS	1270 ABERDEEN ST	PO/VO No.			
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY		
		ACCEPTANCE STD.	ASTM 1417/QS-038	REV./DATE	2005
PROJECT	407 FWD X TUBE, 212/205 HIGH AFT/FED X TUBE,				
ITEM(S) EXAMINED	JOB #S 407-37001, 37004, 212/205-37056, 37058, 37689, 37690.				

JOB DESCRIPTION	PROCEDURE No. LT-0002	REV./DATE	TECHNIQUE No. LT-TECH2	REV./DATE
PART No. D407667105/D212664201/D212664101	MATERIAL ALODINED ALUM.		THICKNESS	
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE				

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL FEB 12 08	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION

CARRIED OUT ON 100% EXTERNAL

SURFACE ON:

407 FWD X TUBE JOB#S: 37001, 37004.

212/205 HIGH AFT X TUBE JOB#S: 37056, 37058.

212/205 HIGH FED X TUBE JOB#S: 37689, 37690.

RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		DTR # E 21525	
TECHNICIAN (SIGNATURE):		REPORT REVIEWED BY:	
NAME (PRINT):	JASON HEWETT	NAME INITIALS	
	1 ST TECHNICIAN		
CGSB LEVEL 2	SNT LEVEL	CGSB LEVEL	SNT LEVEL
CGSB REG. No 6156		CGSB REG. No	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Date: Friday, 04/04/2008 8:42:23 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 FWD X-TUBE
Job Number	: 37004		
Estimate Number	: 12348		
P.O. Number	:	Part Number	: D407667105
This Issue	: 04/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D407-667-145 REV B
First Issue	: 25/01/2008	Project Number	: N/A
Previous Run	: 37003	Drawing Revision	: B
	Type : LANDING GEAR	Material	:
Written By	:	Due Date	: 10/03/2008
Checked & Approved By	:	Qty:	1
Comment	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0

CROSSTUBES

CROSSTUBES RESOURCE 1

**Comment:** LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D407--667-145. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.

ml
08 04 07 (1)

Job Completion

